

5/21
DART AEROSPACE LTD

Work Order: 23616

Description: Wearshoe

Part Number: D2746

Drawing: D2746 Rev. B

Qty:

50 57
Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	PF	05.06.21	50
2	PG	Issue P/O: 2008261 Email or ship DXF file to vendor Laser Cut per Dwg D2746 flat pattern D2746. Material release note required	U	05.06.22	50
3	RG	Receive and Inspect for transit damage Ensure the material note is attached	CD	05/07/15	51
4	QC6	Inspect dimensions per template D2746T1	Z	05-08-16	51
5	GB	Deburr if necessary	FF	05.08.16	51
6	GB	Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT8326	FF	05.08.16	51
7	GB	Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746	FF	05.08.16	51
8	QC5	Inspect work to Step 7	Z	05-08-18	51
9	FP	Powder Coat Grey RAL-7012 (Ref. 4.3.5.5) per QSI 005 4.3	PC	05-08-22	51
10	QC3	Inspect Powder Coat	M	05-08-23	51
11	FP	Identify and Stock	PC	05-08-24	51
12	AC	Cost / part: 8.96	SAC	05-08-25	51
13	DC	Close W/O 8.90 Inspect Level 21	(P)	05/08/25	51

Rev	Date	Change	Revised By	Approved
A	98.09.10	New Issue	DS/CP	
B	99.02.24	Added Qty Column, Jigs	DM	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	
D	02.10.24	Re-format	KJ RF	RF

RELEASED
02/10/2013 RF

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

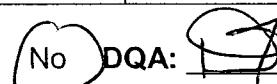
Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA: 

Date: 05/08/05

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Job Costing Report

Dart Aerospace Ltd.
HawkesburyJun 20, 2005
03:23 pm

Work Order No : 0023616
 Project Name : D2746
 Project For : WK527
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2746
 Description : Wearshoe
 Manufactured : Yes
 Amount Req'd : 50
 Amount Done : 0
 Start Date : 06-20-05
 Est Finish Date : 07-10-05
 Act Finish Date :
 Drawings Reqd : No.
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

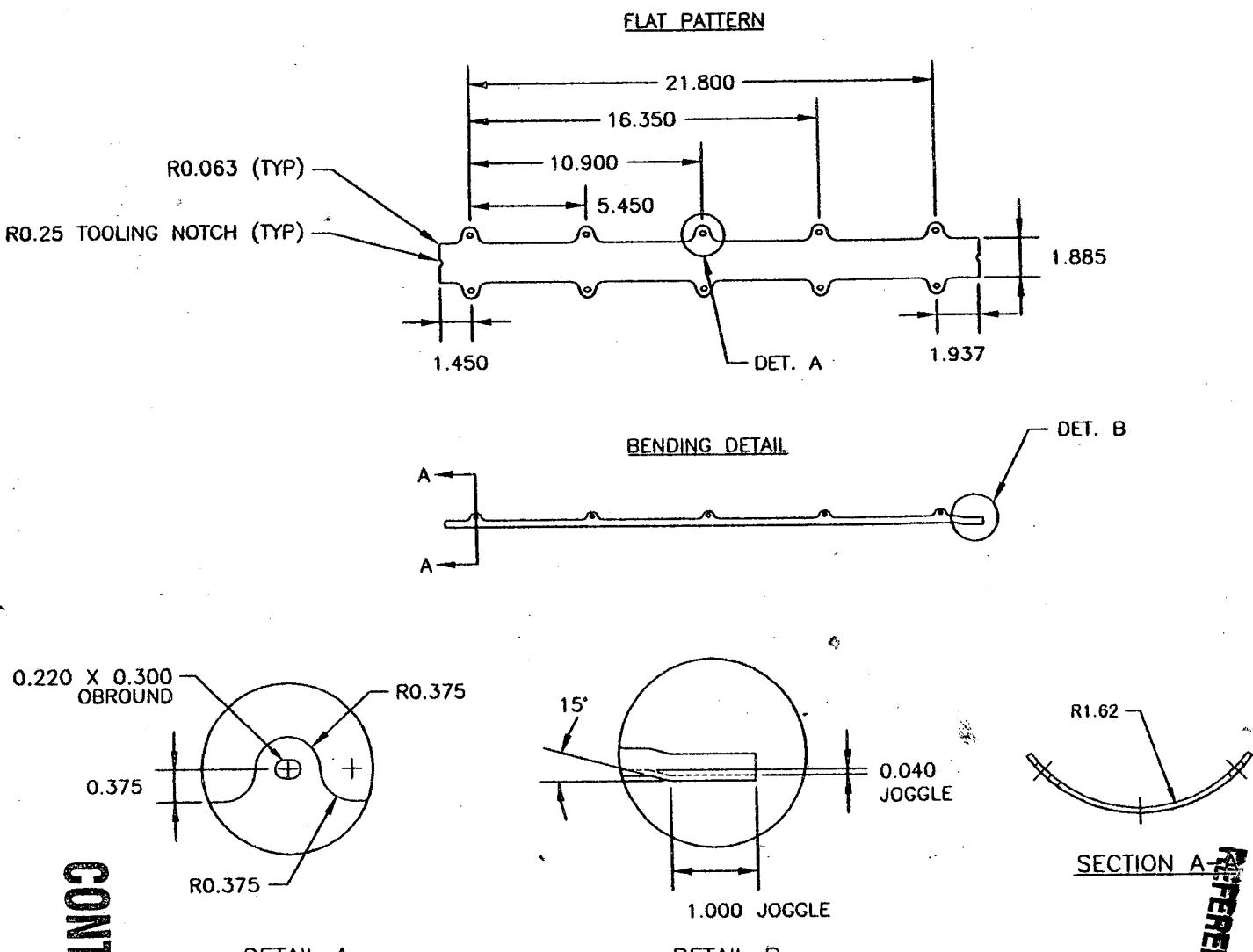
Department Code:
 Burden Flags : NNNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00



MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL
20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NOTE: THIS PART CAN BE MADE BY MODIFYING D2656-21

RELEASED
98.08.03 DS

DART

DESIGN <i>RF</i>	DRAWN BY <i>JG</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>RF</i>	APPROVED <i>RE</i>	DRAWING NO. D2746
DATE 98.08.18	TITLE NEW ISSUE	SCALE 1:8
A	98.04.16	
B	98.08.18	RE-DESIGN

CONTROLLED COPY

NEW ENGLAND
STEEL

New England Steel is located
in Woburn, Massachusetts.
Established 1912, New England
Steel is a leading producer of
structural, plate, sheet, coil and
rebar products.

New England Steel
is a member of the
American Iron and
Steel Institute.

TEST CERTIFICATE

REF ID: 002/002

SPECIFICATION PH40070E002

SPECIFICATION ASTM A36 C57 TYPE A

CERTIFICATE NO. T-002/002

PAGE 1 of 1

CUSTOMER NUMBER

PRODUCT SMA WIRE COIL

DATE 31 March 2005

CUSTOMER ID#

DIMENSIONS 0.046" x 48" x 50ft

ROLL NUMBER	HEAT NO	CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (PER SPECIFICATION - ASTM A36)						7				
		C	Mn	P	S	Cu	N	Cr	Mo	V	Nb	Ti	Al	Si	0.02	0.02	0.02	YIELD	T.S.	KELVIN	HARDNESS	7	LENGTH	
		ASTM																						
RA-56118-00	639181	4	1.1	.20	.12	.05	.12	.10	.20	.4	.7	.1	.1											
RA-56118-00	639184	6	3	.20	.12	.05	.12	.10	.20	4	7	1	1											
RA-56118-00	639185	3	1	.20	.12	.05	.12	.10	.20	1	5	1	1											
RA-56118-00	639186	6	.10	.20	.12	.05	.12	.10	.20	4	6	1	1											
RA-56118-00	639187	6	.10	.20	.12	.05	.12	.10	.20	4	6	1	1											
RA-56118-00	639188	5	.10	.20	.12	.05	.12	.10	.20	4	6	1	1											
RA-56118-00	639189	5	.10	.20	.12	.05	.12	.10	.20	4	6	1	1											

YIELD (0.02% PROOF STRESS) (kg/mm ²)	GAUGE LENGTH (L/L) (mm/mm)	PLASTIC STRAIN RATIO (R) (L ₀ /L ₁)	IMPACT TEST (ASTM E20) (J) (kg/mm ²)	CARBON EQUIVALENT VALUE (CE) (ASTM A36) (%)
(A)=56.7 kg/mm ²	(B)=0.025 mm/mm	(C)=1.00	(D)=27 J	(E)=0.45%

THE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION.

18 yr CRMS
APPROVED *John M. Moore*
OC METALLURGIST